

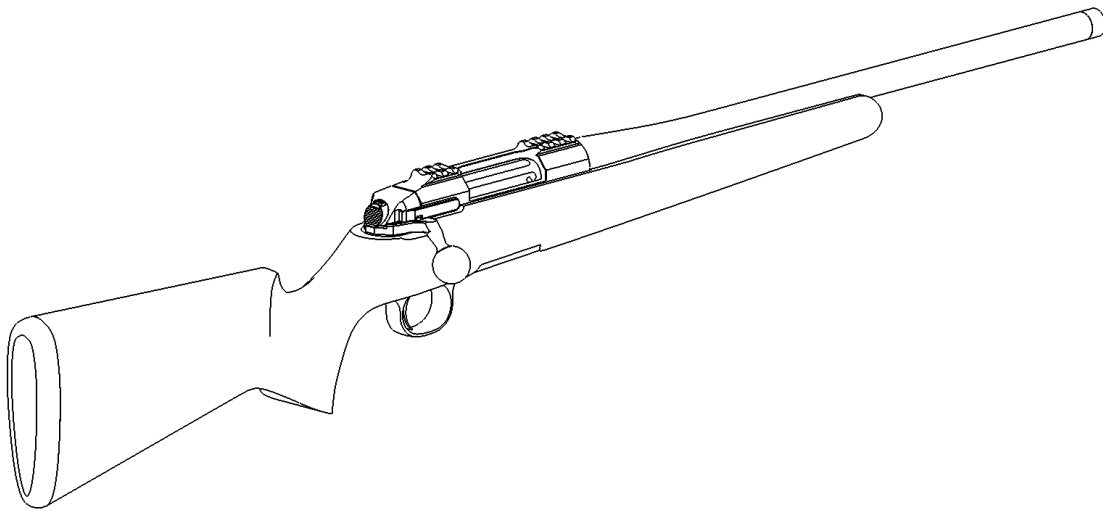


Manual

STEEL *ACTION* HS/HM

STEEL *ACTION* HSL/HML

Hunting Short
Hunting Medium



Steel Action GmbH Georg-Elser-Straße 3-5, 51147 Köln, +49 (0) 2203 1869978

Email: info@steel-action.de

Website: www.steel-action.de

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1 Important safety instructions

The rifle should be exclusively used by TRAINED USERS who have been instructed on the safe handling of rifles.


1.1 General remarks


This manual is important for the safe operation of the rifle. Please retain this manual in a safe place and remember to include it if you sell or pass on the rifle to a new owner.


Please read this manual before using the rifle.


Misuse could lead to SEVERE INJURIES or even DEATH.

1.2 Clarification of symbols

 Immediate danger.
Non-compliance can lead to severe injuries or death.

 Potential danger.
Non-compliance can lead to severe injuries or death.

 Possibly dangerous.
Non-compliance can lead to minor injuries or material damage.

 Additional information regarding the rifle and practical use.

1.3 Safety Instructions

The following safety instructions are very important and must be followed. Ignoring these instructions can lead to severe injuries to yourself and other people or cause major damage to your rifle and or other property.

It is important to be aware of the dangers associated with using a firearm and to follow all safety instructions described within the manual in addition to any local rules and regulations.

1.4 General Rules

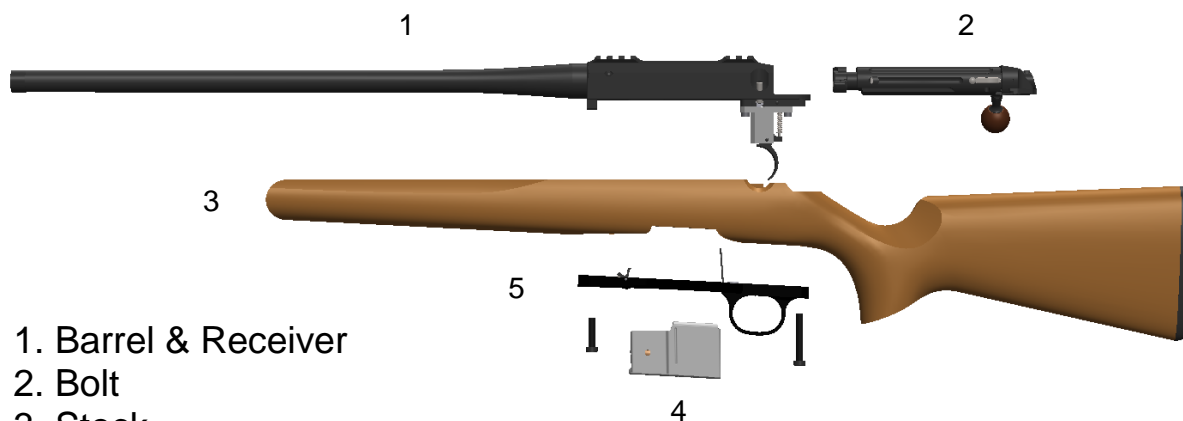
- The rifle is always to be treated as if it was locked and loaded until you are absolutely sure it is unloaded by unloading the gun.
- Before firing make sure that a backstop is present and there is no danger to the safety of others.
- Never point the muzzle of the barrel of a loaded or unloaded firearm toward a person.
- Never leave a loaded gun unattended.
- Never leave a firearm unattended. Rifles and ammunition are to be kept locked up separately, so that children and unauthorized individuals have no access.
- Never cede your rifle to unauthorised individuals or those who have not thoroughly inspected the safety instructions and manual regarding the handling of the rifle.
- Make sure the rifle always stays decocked (on safety) until you intent to fire.
- Only use high quality cartridges of correct type and calibre conforming to CIP standards. Always ensure they are clean, dry and undamaged before loading.
- Before firing always check if the barrel is de-oiled and free of dirt or foreign bodies.
- Never try to modify the rifle on your own accord and only use approved parts on the rifle.
- Only ever load your rifle right before use.
- Unload your rifle before climbing or leaving high seats; before you cross obstacles; before entering any building; before entering a vehicle; when you temporary store or put away your rifle.
- While firing always wear appropriate glasses as well as earplugs or ear defenders. Make sure that individuals in your proximity are protected in a similar manner.

2 Product description

2.1 Technical Data

	Modell HS	Modell HM
Action	Straight-pull rifle	
Locking mechanism	Rotating bolt head	
Caliber	.308 Win.; 7mm-08 Rem.; .243 Win.; .260 Rem.;	.338 Win.Mag.; .300 Win.Mag.; 7mm Rem.Mag.; 9,3x62; 8,5x63; 8x57 IS; .30-06 Spr.; .270 Win.
Trigger	One-stage trigger 2,0 lb Adjustable one-stage trigger 1,4-4,5 lb	
Safety system	Decocking Safety System	
Base for mounting	Integrated Picatinny-Rail (NATO STANAG 4694)	
Barrel length	510 mm / 450 mm	610mm / 560 mm / 510 mm
Total length	1010 mm / 950 mm	1120 mm / 1070 mm / 1020 mm
Muzzle thread	M15 x 1	
Weight without Scope and with wooden stock	3.300 g	3.400 g
Magazine capacity	5 Shot	5 Shot / 4 Shot Magnum

2.2 Assembly for Cleaning (Picture 1)



- 1. Barrel & Receiver
- 2. Bolt
- 3. Stock
- 4. Magazine
- 5. Magazine Frame

Picture 1

2.3 Key Features

The Steel Action straight-pull action rifle is built using our latest design and innovation and is a highly accurate hunting rifle. It is easy to handle with:

- a decocking safety,
- a one-stage trigger,
- a detachable magazine,
- an integrated picatiny rail,
- a M15x1 thread at the end of the barrel for mounting sound moderators.

A change of calibre is possible by swapping the barrel and receiver.

3 Handling

3.1 Before Use

Always make sure the rifle is unloaded, meaning there is no cartridge in the chamber or the magazine before handling the rifle.



DANGER

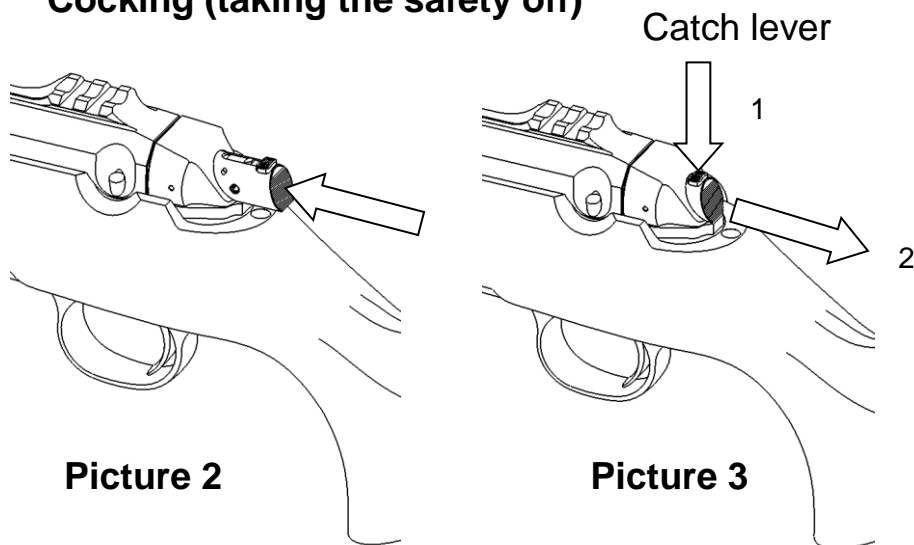
Handling the rifle without first checking if it is loaded.

The rifle is delivered with a protective layer of oil and grease and must therefore be cleaned before it is first used.

3.2 Safety system and bolt handle lock

The safety system of the "Steel Action" Rifle Model HS and HM is based on a decocking system. By decocking the firing pin spring, the firing pin is disengaged and unable to fire. The firing pin spring is cocked with the safety slide (cocking slide) right before the shot. In the secured (uncocked) position of the safety slide, the bolt handle is also locked to prevent unintentional opening of the bolt assembly when moving the rifle, provided the handle was fully closed.

3.2.1 Cocking (taking the safety off)



Push the Cocking slide (Safety slide) with your thumb all the way until it stops (Picture 2), then lift off your thumb. By doing so, the cocking slide (safety slide) locks into its cocked position (Picture 3).



DANGER

Under no circumstances should you put your fingers into the trigger guard when engaging (cocking) or disengaging (uncocking) your rifle. Doing this may lead to accidentally pulling the trigger if the rifle is loaded!



INFO

To silently cock the rifle the catch lever must be supported by your thumb from above. After pushing the slide forward into position, slowly release your thumb.



INFO

In the cocked state the red mark is visible as a warning.

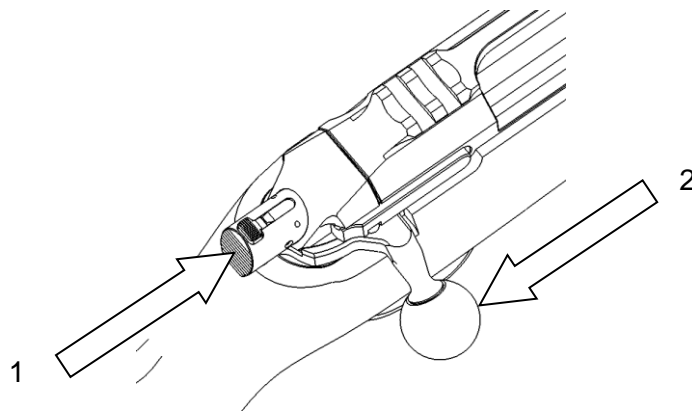
3.2.2 Decocking (Engaging the Safety)

To decock (disengage) the rifle the catch lever on the safety slide must be pushed downwards with your thumb (unlocking) and be allowed to slide back into its initial position (Picture 3).

3.2.3 Bolt Handle Lock

This prevents unintentional opening of the bolt assembly. It activates automatically when the safety is engaged. In this case the bolt handle is fully locked and does not move.

Safe decocking: Using your thumb, push forward the cocking slide (safety slide) slightly forward (1) (about 2 mm). At the same time use your index and middle finger to swing back the bolt handle (2) (decocking). Now you can pull back the bolt (Picture 4).



Picture 4

3.3 Loading the Rifle



DANGER

Never load or unload the rifle in a vehicle, a building or any other tight space (unless you are on a shooting range).



WARNING!

Before loading always wipe away any excess oil and grease. Also make sure there is no dirt or obstructions inside the barrel.



DANGER

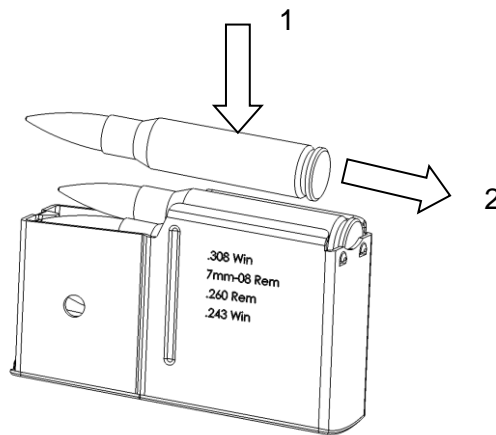
Always point the barrel end towards a safe direction.

3.3.1 Filling the Magazine

To fill the magazine the cartridges must be pushed one after another into the magazine from above until they snap into place. If done correctly the bottom of the cartridges contacts with the backside of the magazine (Picture 5).

Only use ammunition of appropriate calibre for your rifle.
The right calibre is engraved on your rifle's barrel.

Exclusively use cartridges of high quality conforming to CIP standards. Non factory ammunition or ammunition not complying with CIP requirements may result in may endanger the user and will invalidate the warranty.
Do not use cartridges that are dirty, rusty or damaged.



Picture 5

3.3.2 Inserting the Magazine

Insert the magazine into the magazine well and push it upwards until you can noticeably hear the click of it fixing in place.

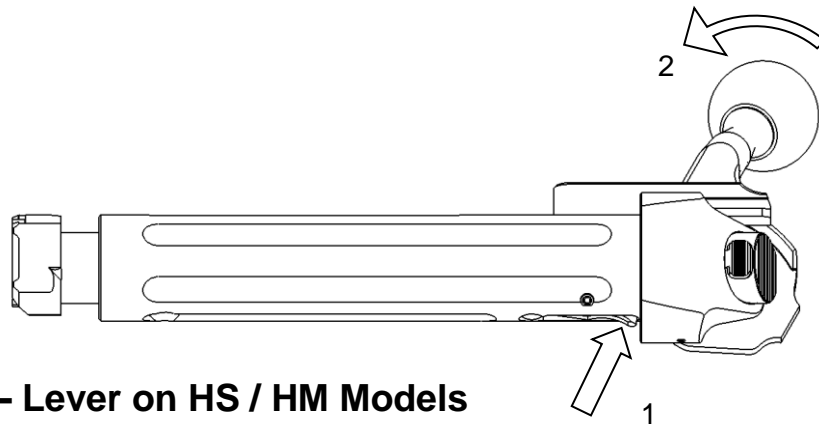
3.3.3 Inserting the bolt

- 1) Push the lever on the left side of the bolt to release the bolt Handle (Picture 6, Point 1). Insert the bolt for about 10mm until it will not move any further (Picture 7, Point 3).
- 2) Pull the trigger (Picture 7, Point 1), then the push the button (Picture 7, Point 2) and keep both of them pressed in.
- 3) Fully insert the bolt into the system past the point where it stopped previously (Picture 7, Point 3). The button and trigger can now be released.
- 4) Cock the bolt handle by pulling it back.

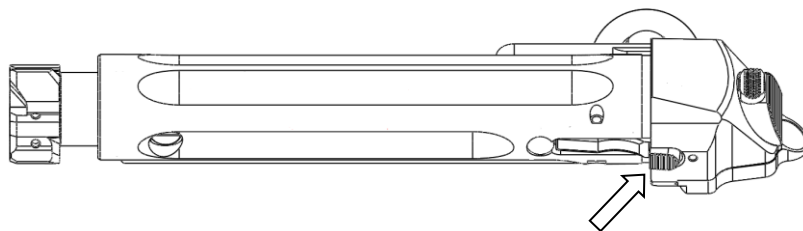


DANGER

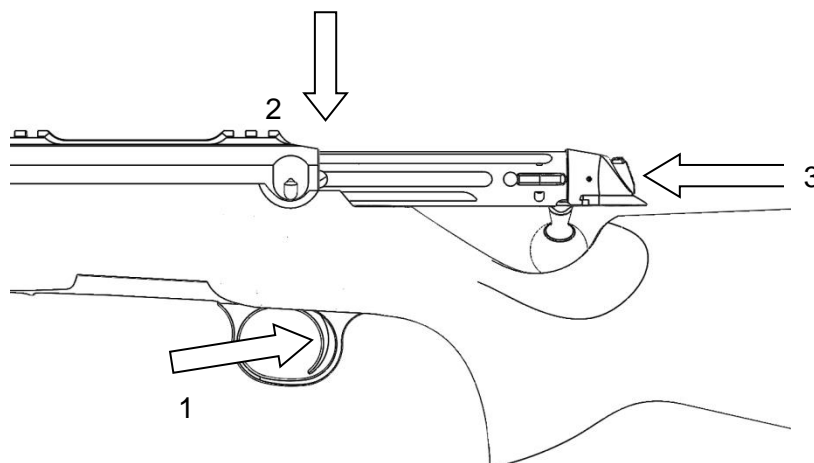
There must be no cartridge in the chamber.
There must be no magazine in the rifle.



Picture 6a – Lever on HS / HM Models



Picture 6b – Lever and button on HSL / HML Models



Picture 7

3.3.4 Firing and repeating



Make sure that there is a safe background behind the target and the surroundings are safe to fire.

- 1) Insert a full magazine into the magazine-well until it clicks and is secure.
- 2) Decock the rifle, by pressing down the catch

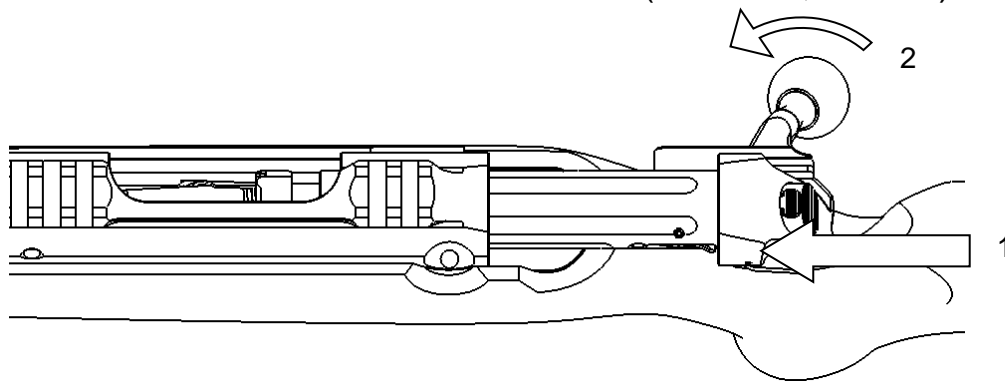
lever on the safety slide with your thumb (unlocking) allowing the slide to move back into its initial position (Picture 3).

- 3) Unlock the bolt with the press of a thumb and pull it all the way back until it will not move any further (Picture 4).
- 4) Push the bolt forward, put the cartridge into the barrel and lock.

The rifle is now loaded and ready to fire.

**INFO**

To “silently” load the rifle, accompany the bolt into the forward position with your thumb, then slowly close the bolt handle (Picture 8, Point 1).



Picture 8

**DANGER**

Never leave a loaded gun unattended.

- 5) The rifle must only be pointed in a safe direction.
- 6) Engage the rifle (Cocking).
- 7) Put your finger on the trigger and release the shot.

**DANGER**

If you are interrupted or when ending the shooting session immediately decock the rifle and unload it.

- 8) Reloading (Repeating): Pull the bolt all the way back to the stop using the bolt handle and then push it all the way forward.

3.3.5 Reloading while firing

- 1) Open the bolt
- 2) Insert cartridges through the ejection window onto the feeder until they snap in in the magazine
- 3) Make sure the rifle is disengaged.

3.4 Unloading the rifle

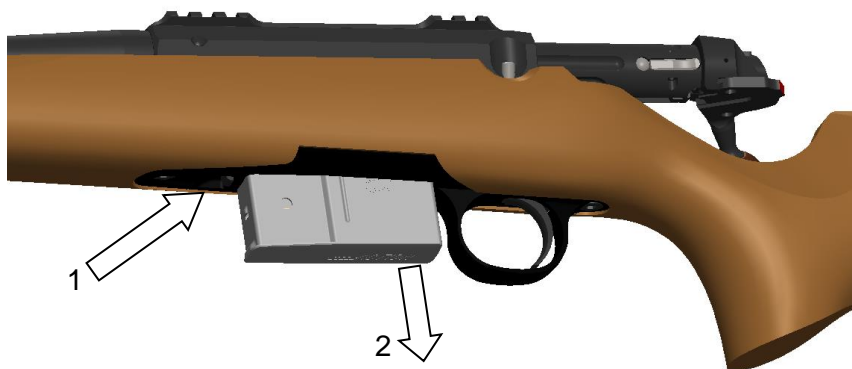
**DANGER**

Never hand over your rifle until it is unloaded.

- 1) Point the rifle in a safe direction.
- 2) Deckock the safety slide (disengaging)
- 3) Open the bolt. The cartridge or the bullet casing will come flying out.

3.4.1 Removing the magazine

- 1) Put your hand underneath the magazine (Picture 9)
- 2) Use your index finger to press the magazine button (1)
- 3) Remove the magazine



Picture 9

3.4.2 Emptying the magazine

To empty the magazine, you must simply push each cartridge forward and out of the magazine.

3.5 Removing the Bolt

**DANGER**

Only remove the bolt when it is decocked.

- 1) Decock the rifle, by pressing down the catch lever on the safety slide with your thumb (unlocking) allowing the slide to move back into its initial position (Picture 2).
- 2) Open the Bolt (Picture 4, Point 2).
- 3) Push the lever on the left side of the bolt to release the bolt handle (Picture 6, Point 1).
- 4) Keep both the trigger and the pin (Picture 7, Point 2) pressed.
- 5) Take the bolt out of the system.

3.6 Adjustment of trigger weight

**DANGER**

Only remove the bolt when it is decocked.

- 1) Remove the bolt (see 3.5).
- 2) Put the included 2mm hex key through the hole in the trigger guard until it snugly fits into the head of the adjustment screw (Picture 10).
- 3) Set up the desired trigger weight by turning the hex key (Picture 10):
 - Clockwise rotation increases the trigger weight.
 - Counter-clockwise rotation reduces the trigger weight.

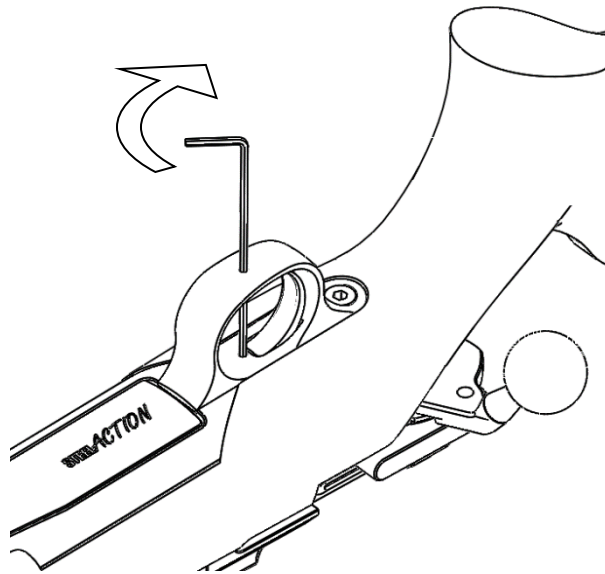
The hex key is delivered with this instruction manual.

**INFO**

A quarter turn reduces or increases the trigger weight by approx. ¼ lb (0,1kg).

**CAUTION**

A trigger weight below 1 ¼ lb (0,5kg) could lead to unintentional triggering of the shot.



Picture 10

4. Disassembly / Assembly

4.1 Disassembling the System

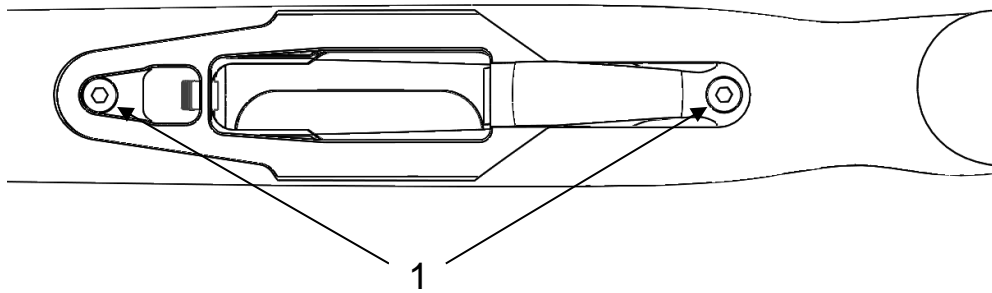
**DANGER**

Before disassembly, the rifle must be unloaded. Make sure that the barrel and chamber are empty.

**CAUTION**

Never disassemble the rifle further than instructed in the manual.

- 1) Remove the magazine (check 3.4.1).
 - 2) Remove the bolt (check 3.5).
 - 3) Take the system out of the stock.
- Loosen the screws in an alternating fashion (Picture 11, Point 1) to avoid damage.
 - Take off the magazine frame and trigger guard.
 - Remove the system from the stock.



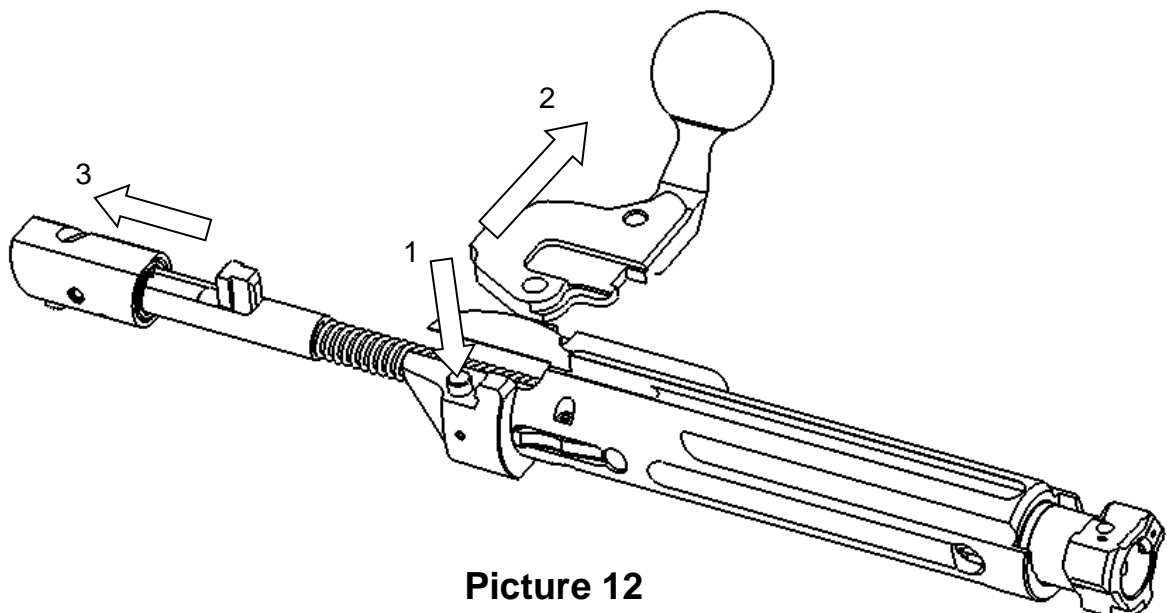
Picture 11

4.2 Reassembling the system

To reassemble the cleanable parts simply follow the disassembly instructions in reverse order and ensure the screws are properly tightened.

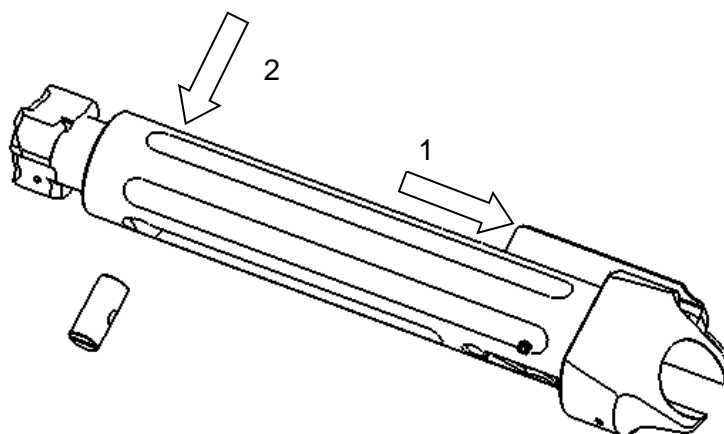
4.3 Disassembling and Reassembling the Bolt

- Push in the lever cam (Picture 12, Point 1).
- Remove the bolt handle out of the way (Picture 12, Point 2).
- Take out the firing pin and the safety slide as one unit (Picture 12, Point 3).



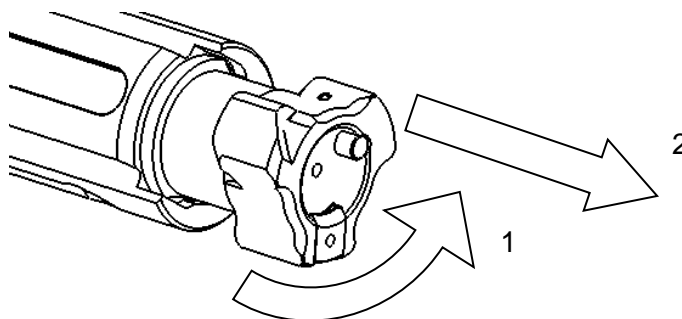
Picture 12

- Move the slide about 5 mm back until the bolt-cam is lined up with the opening (Picture 13, Point 1).
- Push out the bolt-cam from the other side (Picture 13, Point 2).



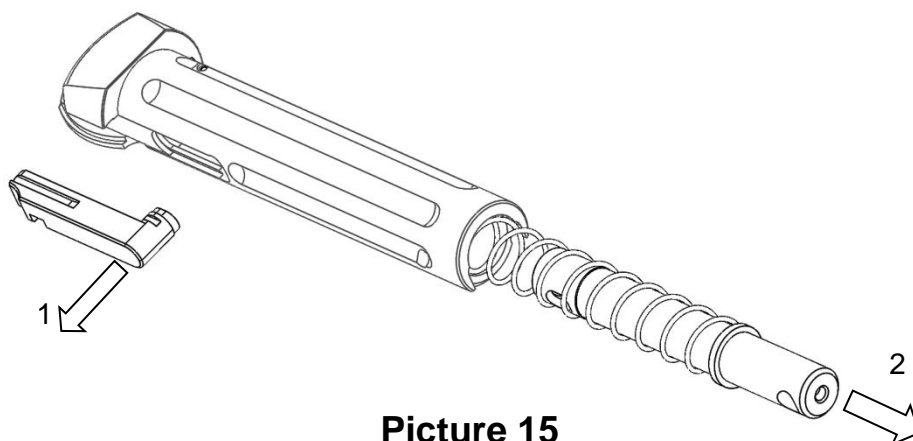
Picture 13

- Turn the bolt head into the displayed position (Picture 14, Point 1).
- Remove the bolt in the axial direction (Picture 14, Point 2).



Picture 14

- Remove the slide in the forward position (Picture 15, Point 1).
- Remove the guid-bolt in axial direction (Picture 15, Point 2).



Picture 15



CAUTION

The guid-bolt is under spring pressure. When removing the slide, backup the guid-bolt with your thumb at all times.

To reassemble the bolt, follow these steps in reverse order.

5 Care and Maintenance

The flawless functionality and precision of the rifle can only be sustained by appropriate maintenance. After every use the rifle must be cleaned and protected against corrosion. After every shooting session clean the inner barrel and protect it against corrosion. Wooden stocks must be treated with appropriate products in accordance with instructions. The rifle must be protected against water and damp conditions.

For optimal care of your Steel Action HS/HM we recommend high quality branded products like Brunox Turbospray, Fluna Gun Coating, as well as high quality products for stock maintenance.

For normal cleaning it will suffice to disassemble or remove the Magazine and bolt

If the rifle has been exposed to water, extreme moisture or has become dirty, it is recommended to disassemble or remove and clean the following parts:

- Magazine
- Bolt
- Magazine frame with trigger
- Barrel with receiver (System)
- Scope

5.1 Barrel Cleaning

To avoid corrosion on the inside of the barrel, the barrel should be cleaned immediately after every usage. To do that you need to remove the bolt.



DANGER

Before cleaning remove the magazine and examine if the chamber is empty.



CAUTION

For cleaning use a synthetically coated rod of appropriate calibre. Always insert the rod from the chamber.



CAUTION

Solvents can damage the surface of the rifle. Before using a cleaning agent or any solvents follow the instructions of the product's manufacturer.

- 1) Unload the rifle (see 3.4).

- 2) Remove the bolt (see 3.5).
- 3) In place of the bolt insert a cleaning aid for the exact guidance of the cleaning rod down the centre of the bore.
- 4) Clean the barrel bore and chamber from back with appropriate liquid or grease (follow the product's instructions) using an suitable bronze or plastic rod of the right calibre.
- 5) Check if cartridge deposits have accumulated on the spring. If necessary clean the spring with a cleaning agent (follow the product's instructions) for cartridge deposits from the store.
- 6) Dry the barrel bore and chamber from the back with a synthetically coated rod of appropriate calibre until fully dried.

5.2 Outer wood surfaces

For the maintenance and preservation of the outer wood surface we recommend using high quality maintenance product for stocks. Please pay attention to the product's instructions.



INFO

So called "Water spotting" on the stock after rain cannot be avoided. Depending on how much limestone or dust and dirt particles are contained in the rainwater this effect is more noticeable. It is not a flaw of the stock's finish.

5.3 Outer metal surfaces

All metal parts of the rifle are always to be kept clean and slightly oiled.

For the maintenance and preservation of the outer metal surfaces we recommend Brunox Turbospray and Fluna Gun Coating. Make sure to follow the product's instructions.

6 Warranty conditions

6.1 Manufacturer's warranty

The warranty period of Steel Action GmbH amounts to ten years, starting with the date of sale. It includes any defects or damage to the rifle, which are proven to be due to faulty material or manufacturing. Wooden parts on the weapon require special care and, as a natural product, are subject to natural change. The guarantee on wooden parts is excluded.

Within this framework, the manufacturer shall bear the costs for material and labour. To carry out work under this warranty, the rifle must be returned to the dealer or production company in Cologne. Risk and costs of transportation of the rifle (outward and return) shall be borne by the customer. Warranty is performed at the discretion of the manufacturer by repair or replacement of defective parts; all replaced parts will be kept by the Manufacturer.

6.2 Scope of warranty

Work performed under warranty does not cause any extension or renewal of the warranty period for the rifle or its built-in spare parts. The warranty period for installed spare parts expires at the same time as the warranty period for the entire rifle.

6.3 Warranty for gun accuracy

The precision of a rifle depends on a multitude of factors. The most important factor is the ammunition. Not every barrel fires equally well with every type of ammunition, there may be considerable differences in accuracy depending on the ammunition used. You should use branded scopes, mounted by a specialist, and sight in the ammunition to your rifle. It is recommended to test several types of ammunition. Ammunition from the same manufacturer may exhibit varying accuracy and impact point characteristics from one manufacturing run to the next and from one rifle to the other. When the optimum of ammunition, rifle scope and mount are selected, we provide a warranty for the excellent accuracy of our rifles. Complaints regarding gun accuracy must be brought forward in writing within 20 days after the date of sale. We reserve the right to submit the rifle to an independent institution for verification (DEVA or Staatliches Beschussamt) [government proofhouse]. If excellent gun accuracy is

confirmed there, we are entitled to claim the costs incurred for the tests from customer.

6.4 Warranty exclusions

The following is excluded from the warranty:

- 1) Damage that is caused as the result of normal wear and tear, or with no observance of the operating instructions or improper use or handling resulting in mechanical damage of any kind.
- 2) Damage that is the result of force majeure or environmental influences.
- 3) Repairs, treatment or changes to the gun performed by third parties.
- 4) Use of reloaded or non CIP accredited ammunition.
- 5) Blueing carried out by a third party.
- 6) Optical sights provided to the customer.

We also are not liable in any way for any assault or property damage, that results from the use of the rifle whether committed criminal or otherwise.